

Work Order ID 82165

\*82165\*

March-23-12 1:17:40 PM

Item ID: D2512

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Basket Lid 205/350

Start Date: 23/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/03/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: 121602 0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512  
2-Cut (4) D2236 From D3166-3  
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305  
4-Weld as per Dwg D2512 using Welding Jig DT 9436  
Deburr as required  
\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

1X PL 12-05-28

TRAINING → CC / 12-5-28

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Memo

0.00

Quality Control

12-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**\*82165\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 23/03/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 02/04/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

QC6- Inspect dimensions to drawing

0.00

**\*120\***

0.00

QC

## Memo

## Quality Control

Pressure Wash per QSI005 4.3

0.00

**\*125\***

0.00

HandFinish

## Memo

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*82165\***

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March-23-12 1:17:40 PM

Item ID: D2512 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid 205/350  
 Start Date: 23/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 02/04/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

**\*130\***

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 3:30

OVEN TEMPERATURE: 400 °F

FINISH TIME: 4:00

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

140

**\*140\***

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: 12/05

1/8/19

M121134

1X

0

M.L. 12/05/29

1

0R/12 12/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*82165\***

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Item ID: D2512 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid 205/350  
 Start Date: 23/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 02/04/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>D35-607041</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

1x 6 MU 12/05/30

78681

1 6 SP/BR 12/05/30

12/6/4

MF 12-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

March-23-12 1:18:41 PM

Page 1

Work Order ID: 82165

**\*82165\***

Parent Item: D2512

**\*D2512\***

Parent Item Name: Basket Lid 205/350

Start Date: 23/03/2012

Required Date: 02/04/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF  
 IPP Rev:N06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM  
 VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified  
 by:EC IPP Rev:R  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117

Manufactured

No

100

Each

35.0000

2

2

**\*D2012-117\***

Clevis

**\*\***

N/A

W

### Location

### Loc Qty

### Loc Code

WA005

35

55729

4

69890

31

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
 NOT USED, PLEASE MARK N/A \*\*\*

D2232-1

Manufactured

No

100

Each

14.0000

2

2

**\*D2232-1\***

Basket Hinge

**\*\***

CPL 12.05.28

### Location

### Loc Qty

### Loc Code

WA

14

78992

10

79472

4

2x

D2327-1

Manufactured

No

100

Each

31.0000

2

2

**\*D2327-1\***

Spacer Bushing

**\*\***

CPL 12.05.28

### Location

### Loc Qty

### Loc Code

WA005

31

69728

5

73692

26

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 82165

**\*82165\***

Parent Item: D2512

**\*D2512\***

Parent Item Name: Basket Lid 205/350

Start Date: 23/03/2012

Required Date: 02/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2506 Manufactured No

100 Each 8.0000 1 1

**\*D2506\***

Label Plate

\*\*

*Pl 12-05-28*

Location

Loc Qty

Loc Code

WA006

8

*(79197)*

8

*(1)*

D2581 Manufactured No

100 Each 13.0000 2 2

**\*D2581\***

Mounting Bracket

\*\*

*Pl 12-05-28*

Location

Loc Qty

Loc Code

WA005

13

69739

1

70766

2

77045

1

77523

9

*B83230 - (2)*

D3166-3 Manufactured No

100 Each 8.0000 1 1

**\*D3166-3\***

Basket Hoop

\*\*

*SAY 12-05-22*

Location

Loc Qty

Loc Code

WA

6

81578

6

WA007

2

77294

2

*(1)*

March-23-12 1:18:42 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March-23-12 1:18:42 PM

Page 3

Work Order ID: 82165

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

\*82165\*

\*D2512\*

Start Date: 23/03/2012

Required Date: 02/04/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

914.0022

18

18.94737

\*M304FX0 75-16F\*

Expanded Metal Flat SS

\*\*

SAD 12-05-23

## Location

## Loc Qty

## Loc Code

WA

0.0001156

119180

0.0001156

WA035

914.0020757

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120318

6.8113116

120917

210.99263

121082

320

M 120917

18.9474

M304TS0.750W.065

Purchased

No

100

f

601.3900

43.5804

45.87411

\*M304TS0 750W 065\*

304 SQ Tube .75x.75x.065W

\*\*

SAD 12 05-22

## Location

## Loc Qty

## Loc Code

MAT017

553.7325342

120267

53.7325342

120633

500

MAT018

41

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

M 121170

45.8742

March-23-12 1:18:42 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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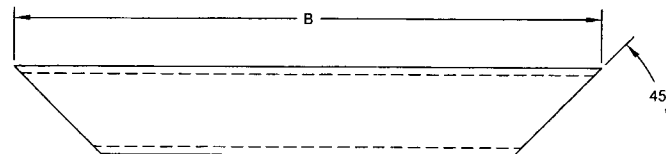
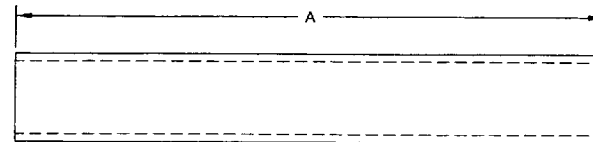
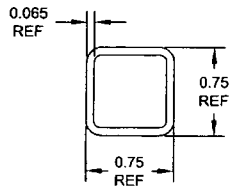
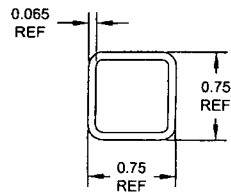
# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 82165 MCO  
12/03/23

RELEASED  
08-08-21-11



## D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

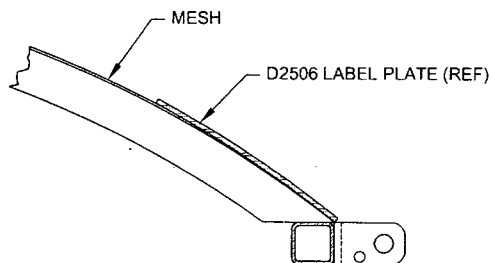
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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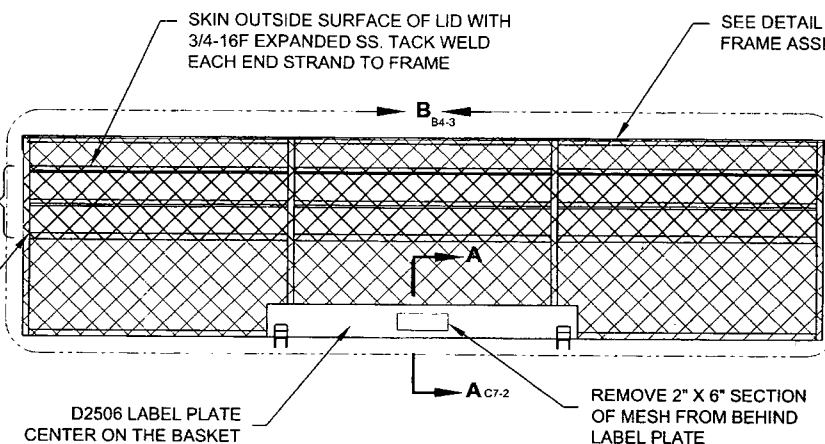




**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



**RELEASED**  
08.06.17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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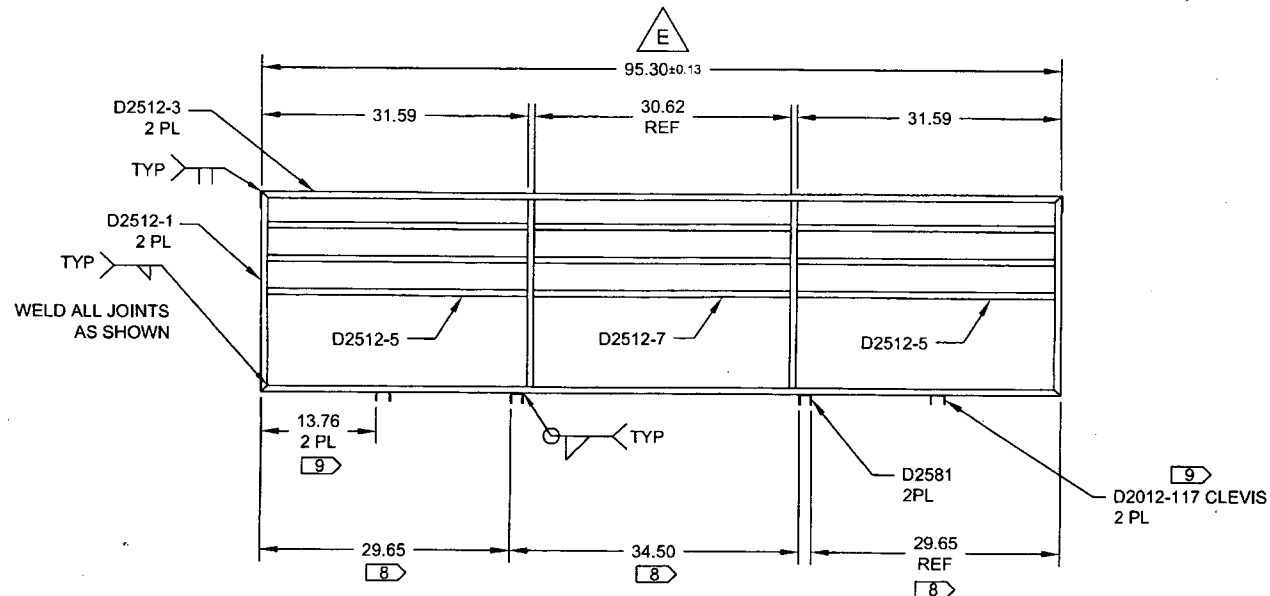
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

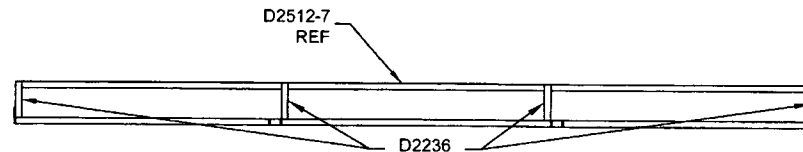
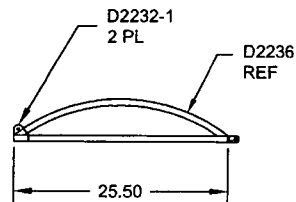
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**NOTE:** Date & initial all entries

82165



**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

**RELEASED**  
08-06-17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	DS	D2512	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	BASKET LID ASSEMBLY (350/212)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

D2232-1  
HINGE PLATE  
(TYP BOTH ENDS)

TRIM MESH AS REQUIRED  
TO ALLOW D2232-1 HINGE PLATE  
TO SIT FLUSH ON FRAME

DRILL 3/8 HOLE AND  
INSTALL D2327-1 USING  
CLOSEST SPACE IN  
EXPANDED METAL  
FOR HOLE LOCATION  
BOTH ENDS

DETAIL E

8.00

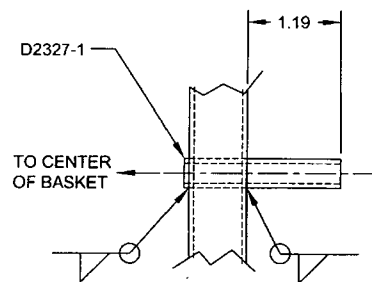
**VIEW C-C SIMILAR BOTH END RIBS** A5-2

4.00  
2X 3 PL

EXPANDED METAL

C

**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

**RELEASED**  
08-06-21/14/17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries